

Work Order ID 80383

February-17-12 2:17:28 PM

80383

PRELIMINARY ISSUE

Page 1

Item ID: D4522-045
 Revision ID: ~~PRELIM~~
 Item Name: Base, Horizontal Swing Arm
 Start Date: 17/02/2012 Start Qty: 2.00
 Required Date: 02/03/2012 Req'd Qty: 2.00
 Reference:

Accept

N900040100

Setup Start *NS1*

Stop *NS2*

Cust Item ID:

Customer:

Approvals: Process Plan: M.C.J.
 QC: _____

Date: 12/02/12 Tooling: _____

Date: _____ SPC (Y/N): _____

Date: _____

Date: _____

Run Start *NR1*

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D4522	RA2 <u>RA3</u> <u>B.H.</u>

100

0.00

100

0.00

Bandsaw

Memo

Jeaspa Bandsaw

CUT BLANKS 1.7" LONG

105

0.00

105

0.00

Outsource5

Memo

Outsource process - Machining

Issue P/O: 16235
 Machine as per Dwg
 Possible Supplier: DAN'S PRECISION
 SEND BLANKS WITH P/O
 Conformity sheet required

CH 12/02/12 (2)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Page 2

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N900040100

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Stop ***NS2***

Cust Item ID:

Customer:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start ***NR1***

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
110 *110* Packaging Packaging	Receive & Inspect for Damage & Mat'l Certs Memo Ensure certificate of conformity is attached	0.00 0.00							<i>42/4/10</i> <i>(2)</i>
120 *120* QC Quality Control	QC6- Inspect dimensions to drawing Memo DIMENSIONAL CHECK,	0.00 0.00							<i>inspect to PAJ</i> <i>Dugally</i> <i>8.2/4/11</i> <i>(42)</i>
122 *122* HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 Memo	0.00 0.00							<i>2</i> <i>φ</i> <i>BLD-4-11</i>

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Page 3

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 Reference:

Accept

N900040100

Setup Start ***NS1***
 Stop ***NS2***

Cust Item ID:
 Customer:

2
2

Approvals: Process Plan:
 QC:

Date: Tooling: Date:
 Date: SPC (Y/N): Date:

Run Start ***NR1***
 Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
124 *124* QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00				2X	✓		M-1 12/04/11
126 *126* Small Fab Small Fab	INSERT HELICOIL Memo	0.00 0.00				2x	✓		12/04/12
128 *128* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 -145122 to P43 0.00 Dugally 5/12/04/12 ②							

POSITIVE RECALL

EFFECTIVE 2/02/12 AUTH

RELEASED 12/08/12 DATE

12-02-13
 16
 8-89 inspectors to Rev
 B Day

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Stop ***NS2***

Cust Item ID:

Customer:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

Identify as per dwg & Stock Location:

0.00

130

Packaging

Memo

0.00

Packaging

8 12/08/20

140

QC21- Final Inspection - Work Order Release

0.00

140

QC

Memo

0.00

Quality Control

12/9/17

PD3392

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

February-17-12 2:17:32 PM

Page 1

Work Order ID: 80383

Parent Item: D4522-045

Parent Item Name: Base, Horizontal Swing Arm

80383

D4522-045

Start Date: 17/02/2012

Required Date: 02/03/2012

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP REV:A NEW ISSUE 12-02-16 JLM VERIFIED BY:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D4522-3P		Purchased	No				Each	0.0000		2			
----------	--	-----------	----	--	--	--	------	--------	--	---	--	--	--

D4522-3P

BASE, HORIZONTAL SWING ARM

M6061T6B1.000X02.00		Purchased	No				f	72.1260		0.29			
---------------------	--	-----------	----	--	--	--	---	---------	--	------	--	--	--

0

M6061T6B1 000X02 000

6061-T6 Bar 1.00 x 2.00

Location	Loc Qty	Loc Code
----------	---------	----------

MAT003	23.646	
--------	--------	--

112567	16.6	
--------	------	--

118106	7.046	
--------	-------	--

MAT004	48.48	
--------	-------	--

120044	0.48	
--------	------	--

→ 120603	48	
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MS21209-C0820		Purchased	No				Each	16.0000		4			
---------------	--	-----------	----	--	--	--	------	---------	--	---	--	--	--

MS21209-C0820

Threaded Insert, 8-32 UNC x 0.33 LG

Location	Loc Qty	Loc Code
----------	---------	----------

ST305	16	
-------	----	--

120593	16	
--------	----	--

**

**

**

2
② 10/24/10

80 12/02/22

0.29 FT

4
EP 12/04/12
4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

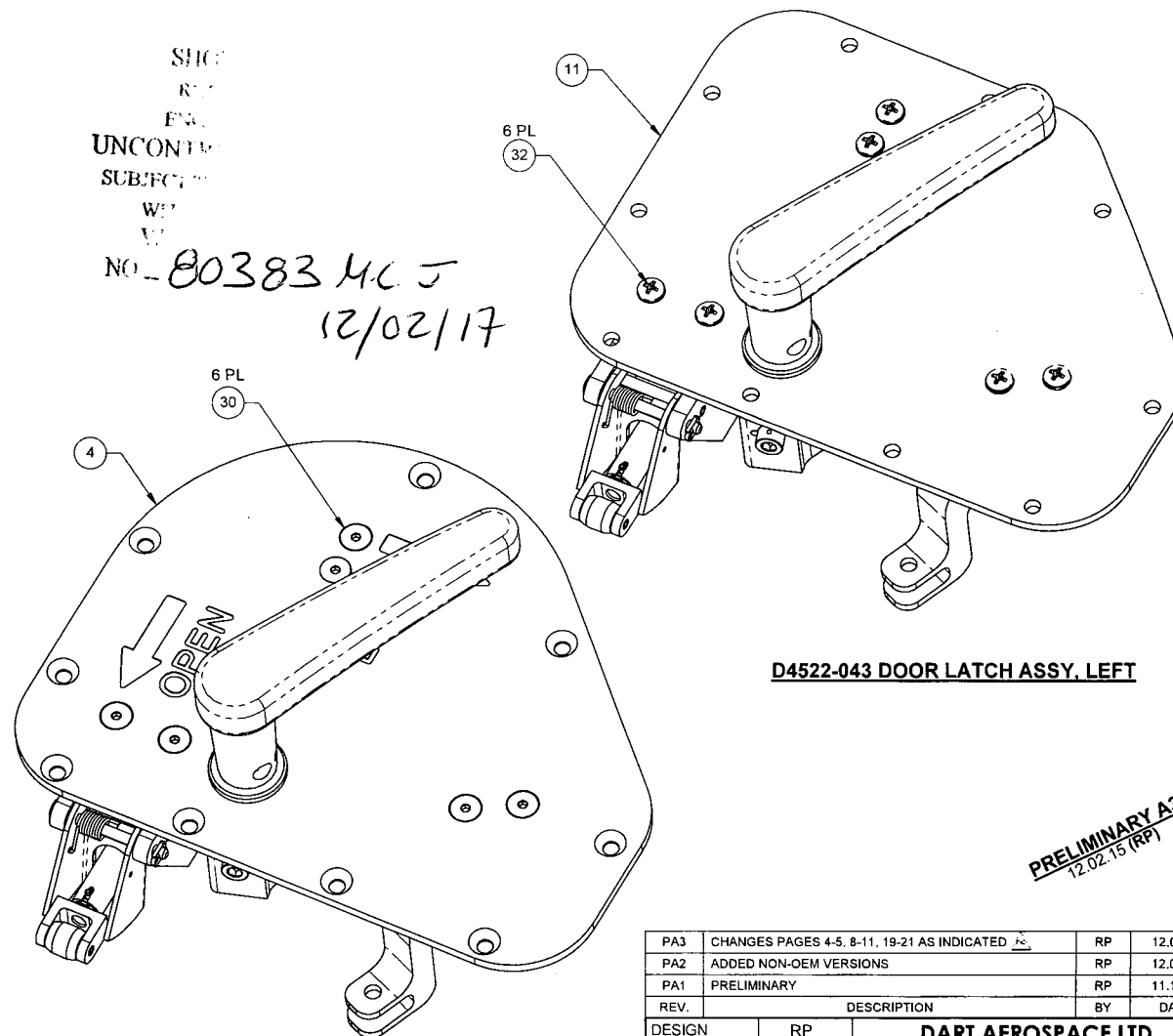
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

ITEM	QTY -041	QTY -043	P/N	DESCRIPTION
	X		D4522-041	DOOR LATCH ASS'Y, LEFT, OEM
		X	D4522-043	DOOR LATCH ASS'Y, LEFT
1	1	1	D4522-045	BASE, HORIZONTAL SWING ARM
2	1	1	D4522-047	BASE, VERTICAL SWING ARM
3	1	1	D4522-049	BASE, LATCH SHAFT
4	1		D4522-1	BASE PLATE, OEM
5	1	1	D4522-11	HANDLE SHAFT ARM
6	1	1	D4522-13	HANDLE SHAFT ADAPTER
7	2	2	D4522-17	LINKAGE
8	2	2	D4522-19	LINKAGE
9	2	2	D4522-21	LINKAGE
10	1	1	D4522-25	LATCH SHAFT
11		1	D4522-31	BASE PLATE
12	1	1	D4522-9	VERTICAL SWING ARM
13	1	1	D4529-041	HORIZONTAL SWING ARM
14	1	1	D4530-041	LATCH ROLLER
15	1	1	D4531-1	LATCH SHAFT BRACKET
16	1	1	D4574	INTERIOR L-HANDLE, MODIFIED
17	1	1	LE045005S	EXTENSION SPRING (LEE SPRING)
18	1	1	MS-20995-C20	LOCK WIRE
19	1	1	MS16562-193	SPRING PIN
20	1	1	MS16562-223	SPRING PIN
21	1	1	MS16562-227	SPRING PIN
22	1	1	MS16624-4062	EXTERNAL RETAINING RING
23	1	1	MS20392-1P41	DRILLED PIN
24	1	1	MS20392-1R27P	DRILLED PIN
25	1	1	MS20392-1R37P	DRILLED PIN
26	4	4	MS20392-1R9P	DRILLED PIN
27	3	3	MS20392-2R41P	DRILLED PIN
28	7	7	MS24665-151	COTTER PIN
29	2	2	MS24665-155	COTTER PIN
30	6		MS24671-14	SCREW, FL-HD, HEX, #8
31	1	1	MS24674-13	DRILLED CAP SCREW, #10
32		6	MS51957-43	SCREW, PN-HD, #8
33	5	5	NAS1149-C-N432-R	FLAT WASHER
34	1	1	NAS42DD628FC	SPACER
35	1	1	T032-180-156L	TORSION SPRING

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY PER DART QSI 044
- 7) WEIGHT: 2.0 lbs
- 8) INSTALL ALL COTTER PINS AND LOCK WIRE IN ACCORDANCE WITH MS33540
- 9) OEM VERSION DEPICTED IN DRAWING
- 10) SHEETS 22 - 24 ARE FOR REFERENCE ONLY AND ARE ONLY **RECOMMENDED** ASSEMBLY STEPS



PA3	CHANGES PAGES 4-5, 8-11, 19-21 AS INDICATED	RP	12.02.15
PA2	ADDED NON-OEM VERSIONS	RP	12.01.10
PA1	PRELIMINARY	RP	11.12.21
REV.	DESCRIPTION	BY	DATE
DESIGN	RP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RP		
CHECKED	CP	DRAWING NO.	REV. PA3
MFG. APPR.		D4522	SHEET 1 OF 24
APPROVED		TITLE	SCALE
DE APPR.		DOOR LATCH ASSY (412)	NTS
DATE	12.02.15	COPYRIGHT © 2012 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

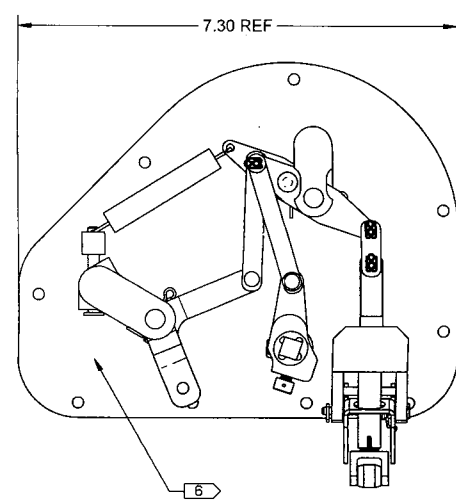
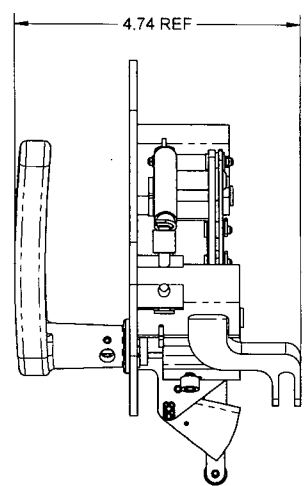
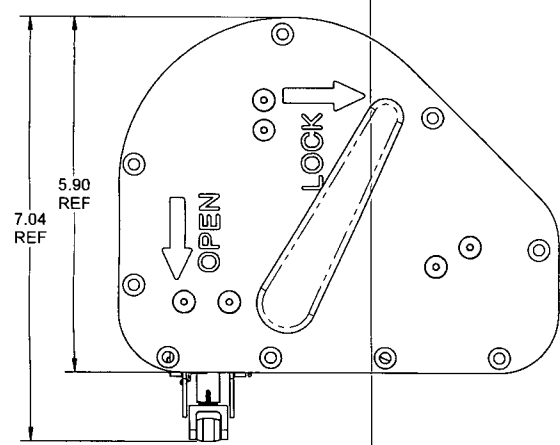
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

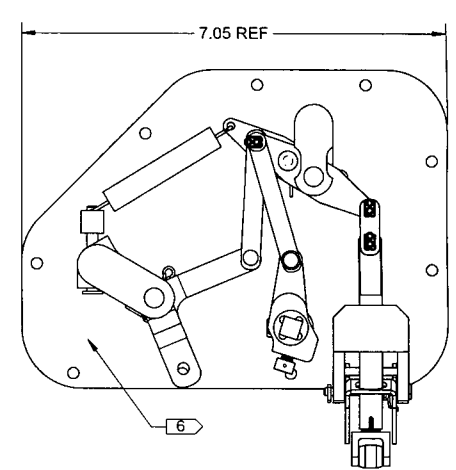
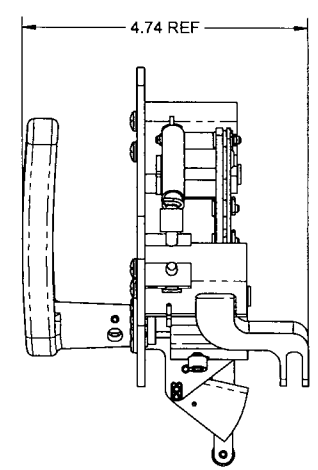
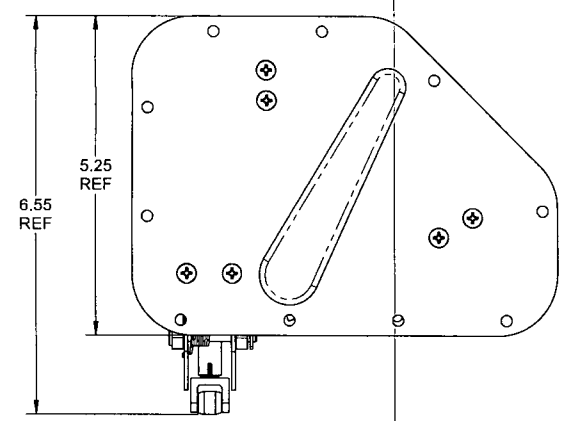
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

80383



D4522-041 DOOR LATCH ASSY, LEFT, OEM



D4522-043 DOOR LATCH ASSY, LEFT

PRELIMINARY A3
12.02.15 (RP)

DESIGN	RP	DART AEROSPACE LTD	
DRAWN	RP	HAWKESBURY, ONTARIO, CANADA	
CHECKED	CP	DRAWING NO. D4522	REV. PA3
MFG. APPR.			SHEET 2 OF 24
APPROVED		TITLE	SCALE
DE APPR.		DOOR LATCH ASSY (412)	NTS
DATE	12.02.15	<small>COPYRIGHT © 2012 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

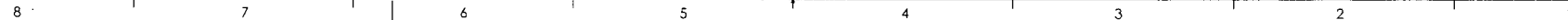
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

8	7	6	5	4	3	2
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NOTE: Date & initial all entries

8 7 6 5 4 3 2 1



C

B i

A

- 3 

8 7 6 5 4 3 2 1 0

3x1 = 3

2x2 = 4

1x1 = 1

2x2 = 4

8x1 = 8

A

PRELIMINARY A3
12.02.15 (RP)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

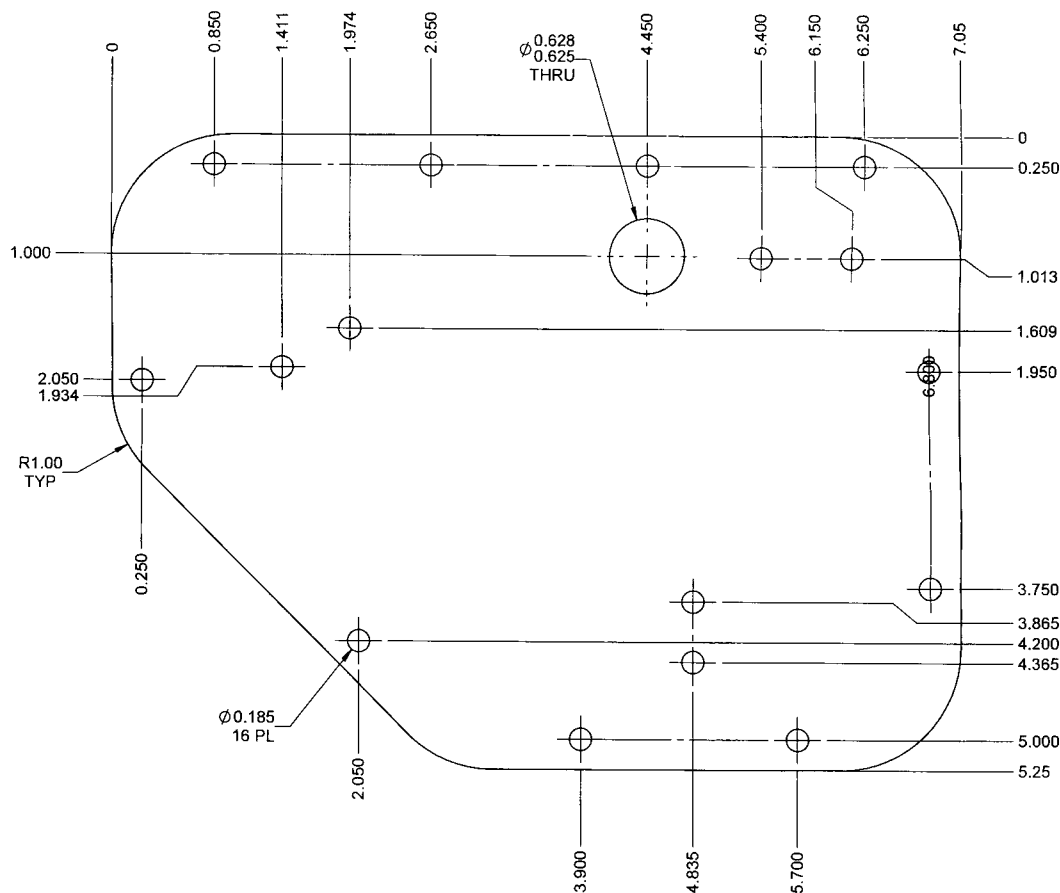
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NOTE: Date & initial all entries

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**NOTES:**

- 1) MATERIAL: 6061-T6/T62 ALUMINUM SHEET, .125 THICK
PER AMS 4025 OR AMS 4027 OR ASTM B209
REF M6061T6S.060
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GLOSS GREY (4.3.5.15) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI044
- 7) WEIGHT: 0.4 lbs

**D4522-31 BASE PLATE**

PRELIMINARY A3
12.02.15 (RP)

DESIGN	RP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RP		
CHECKED	CP	DRAWING NO. D4522	REV. PA3
MFG. APPR.			SHEET 5 OF 24
APPROVED		TITLE	SCALE
DE APPR.		DOOR LATCH ASSY (412)	NTS
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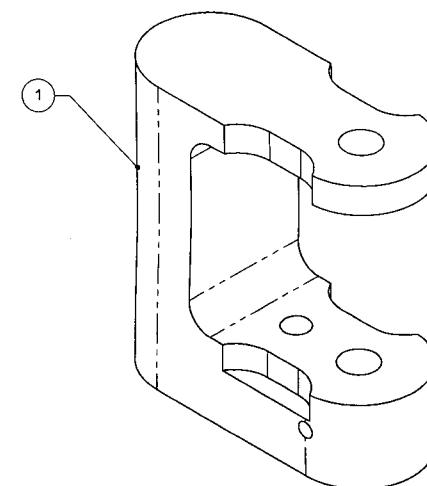
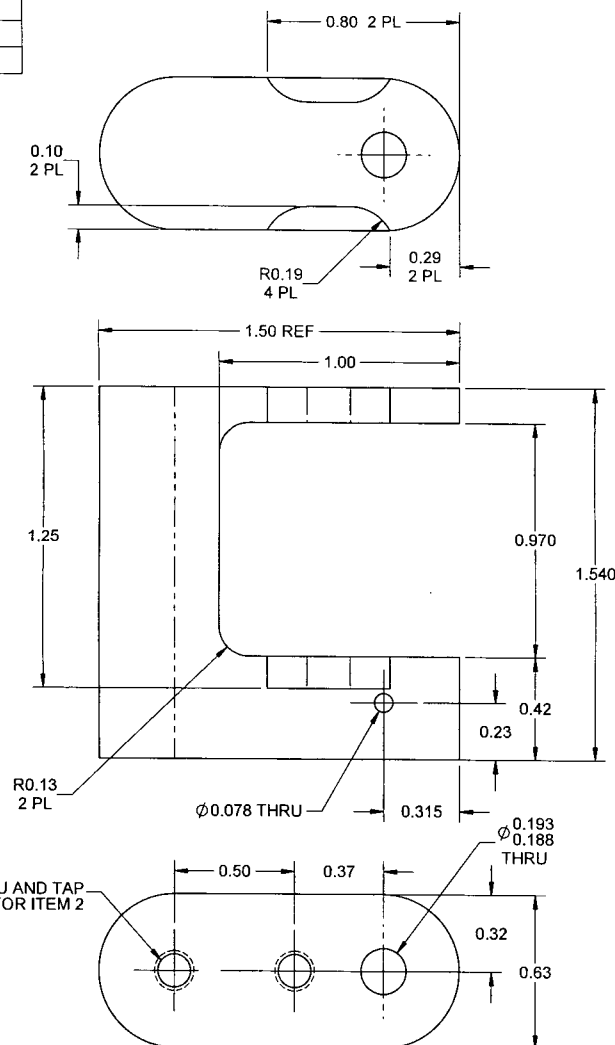
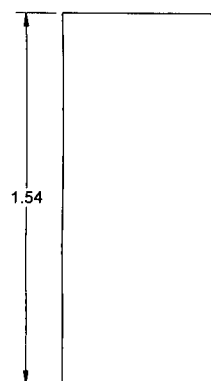
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NOTE: Date & initial all entries

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ITEM	QTY	P/N	DESCRIPTION
1	1	D4522-3	BASE, HORIZONTAL SWING ARM
2	2	MS21209-C0820	THREADED INSERT, 8-32 UNC X 0.33 LG



NOTES:

- 1) MATERIAL: 6061-T6/T62 ALUMINUM PER AMS 4025 OR AMS 4027 OR ASTM B209 REF M6061T6S.060
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI044 6.1
- 7) WEIGHT: 0.07 lbs

D4522-045 BASE, HORIZONTAL SWING ARM

PRELIMINARY A3
12.02.15 (RP)

DESIGN	RP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RP		
CHECKED	CP	DRAWING NO. D4522	REV. PA3
MFG. APPR.		TITLE	SHEET 6 OF 24
APPROVED		DOOR LATCH ASSY (412)	SCALE
DE APPR.			NTS
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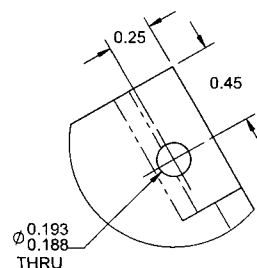
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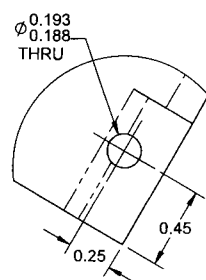
NOTE: Date & initial all entries

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ITEM	QTY	P/N	DESCRIPTION
1	1	D4522-5	BASE, VERTICAL SWING ARM
2	2	MS21209-C0820	THREADED INSERT, 8-32 UNC X 0.33 LG



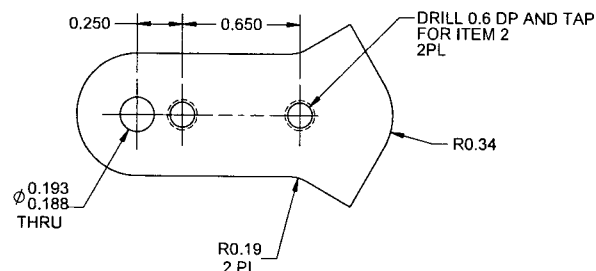
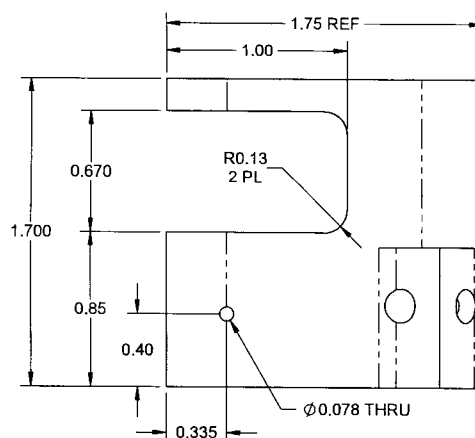
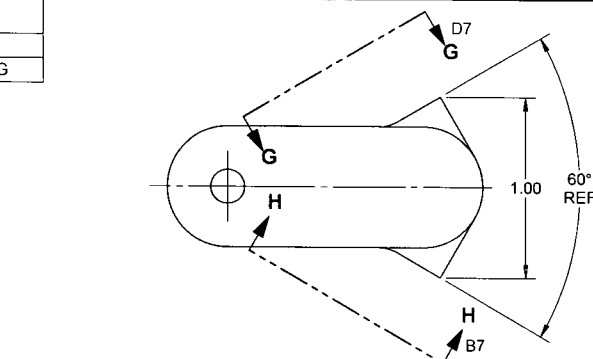
VIEW G-G D4



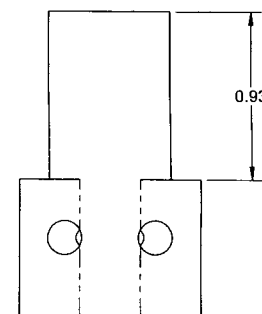
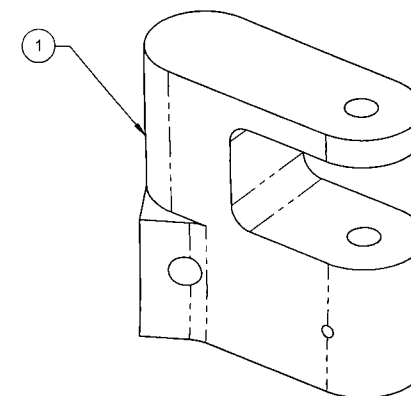
VIEW H-H C4

NOTES:

- 1) MATERIAL: 6061-T6/T62 ALUMINUM PER AMS 4025 OR AMS 4027 OR ASTM B209 REF M6061T6S.080
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI044 6.1
- 7) WEIGHT: 0.14 lbs



D4522-047 BASE, VERTICAL SWING ARM



PRELIMINARY A3
12.02.15 (RP)

DESIGN	RP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RP		
CHECKED	CP	DRAWING NO. D4522	REV. PA3
MFG. APPR.		TITLE	SHEET 7 OF 24
APPROVED		DOOR LATCH ASSY (412)	SCALE
DE APPR.			NTS
DATE	12.02.15	COPYRIGHT © 2012 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

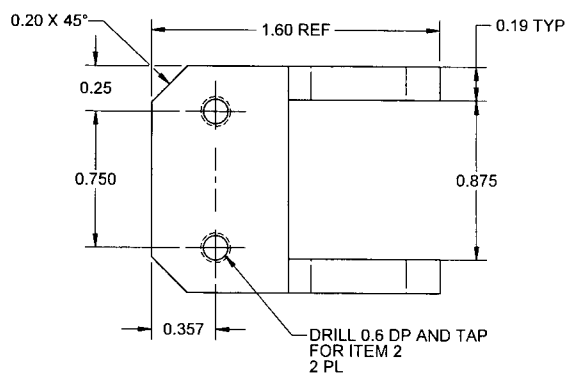
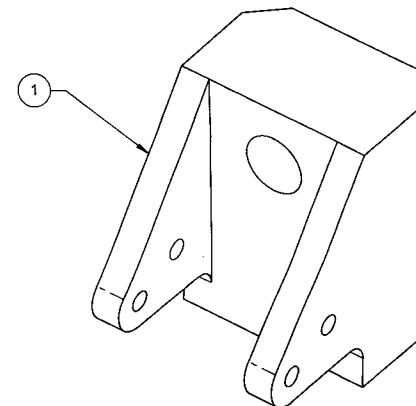
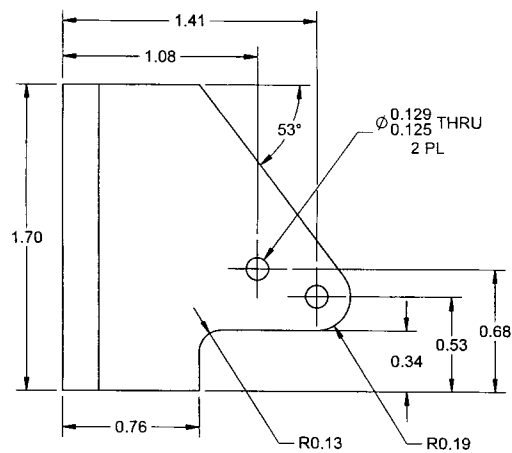
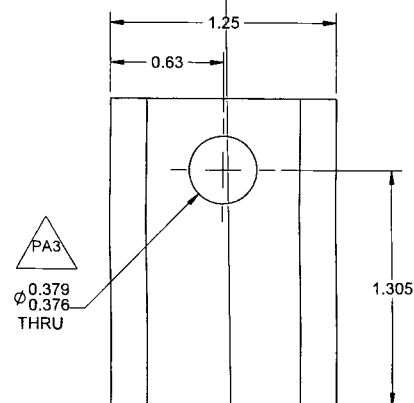
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

80383

ITEM	QTY	P/N	DESCRIPTION
1	1	D4522-7	BASE, LATCH SHAFT
2	2	MS21209-C0820	THREADED INSERT, 8-32 UNC X 0.33 LG

**NOTES:**

- 1) MATERIAL: 6061-T6/T62 ALUMINUM PER AMS 4025 OR AMS 4027 OR ASTM B209 REF M6061T6S.060
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI044 6.1
- 7) WEIGHT: 0.16 lbs

D4522-049 BASE, LATCH SHAFT

PRELIMINARY A3
12.02.15 (RP)

DESIGN	RP	DART AEROSPACE LTD	
DRAWN	RP	HAWKESBURY, ONTARIO, CANADA	
CHECKED	CP	DRAWING NO.	REV. PA3
MFG. APPR.		D4522	SHEET 8 OF 24
APPROVED		TITLE	SCALE
DE APPR.		DOOR LATCH ASSY (412)	NTS
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

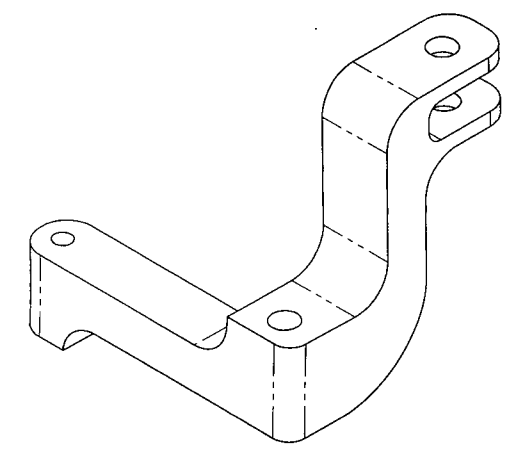
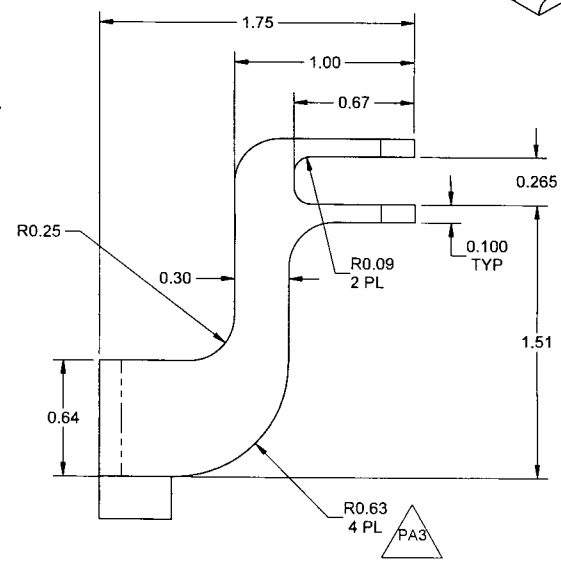
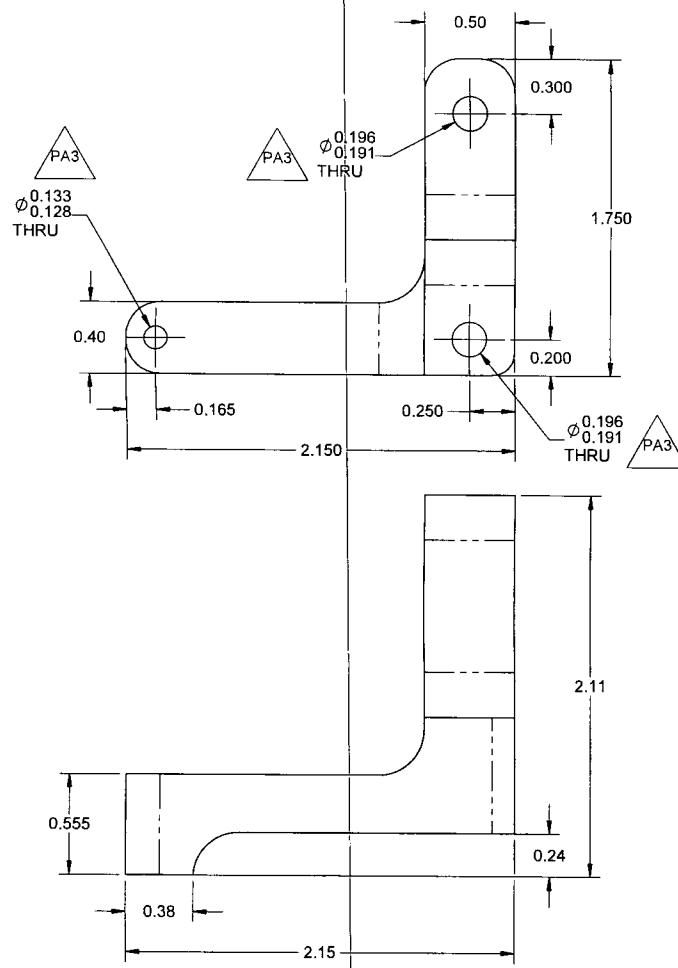
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

80383:



NOTES:

- 1) MATERIAL: AISI 303 SS BAR PER ASTM A582
REF DART SPEC M303B OR
AISI 304/316 SS BAR OR PLATE
PER ASTM A276 OR ASTM A240
REF DART SPEC M304B
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI044 6.1
- 7) WEIGHT: 0.19 lbs

D4522-9 VERTICAL SWING ARM

PRELIMINARY A3
12.02.15 (RP)

DESIGN	RP	DART AEROSPACE LTD	
DRAWN	RP	HAWKESBURY, ONTARIO, CANADA	
CHECKED	CP	DRAWING NO.	REV. PA3
MFG. APPR.		D4522	SHEET 9 OF 24
APPROVED		TITLE	SCALE
DE APPR.		DOOR LATCH ASSY (412)	NTS
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

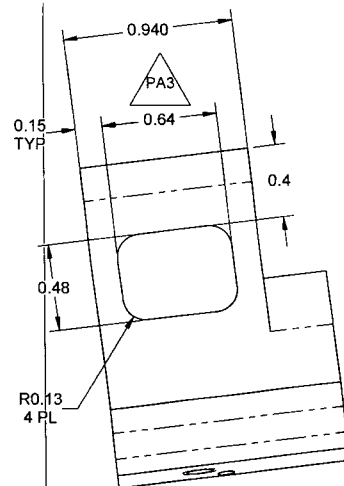
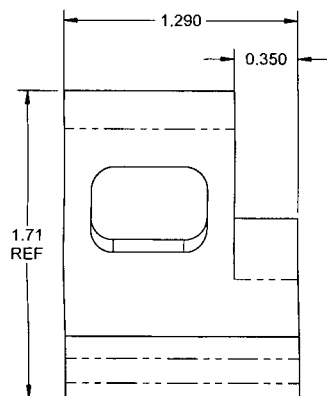
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

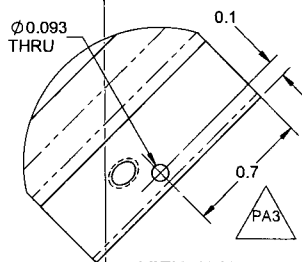
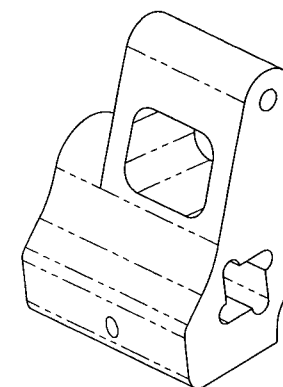
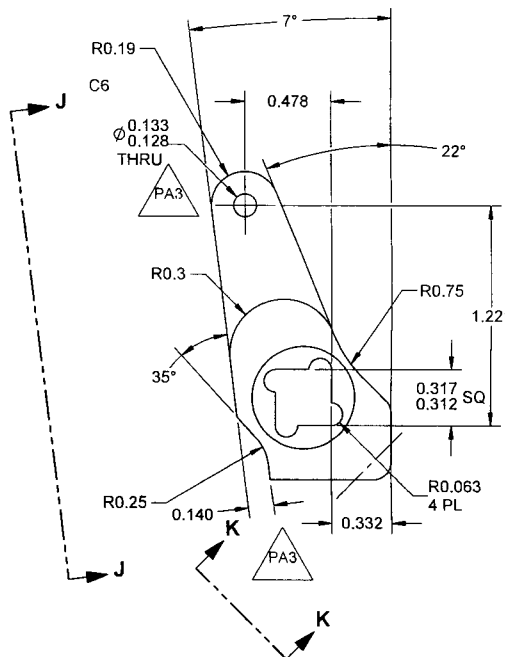
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

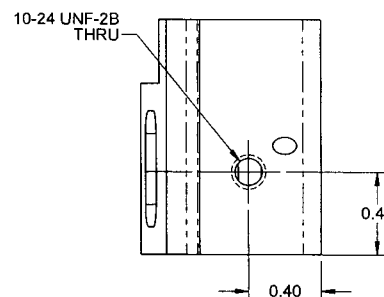
80383



VIEW J-J C4



VIEW K-K



NOTES:

- 1) MATERIAL: AISI 303 SS BAR PER ASTM A582
REF DART SPEC M303B OR
AISI 304/316 SS BAR OR PLATE
PER ASTM A276 OR ASTM A240
REF DART SPEC M304B
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI044 6.1
- 7) WEIGHT: 0.14 lbs

D4522-11 HANDLE SHAFT ARM

PRELIMINARY A3
12.02.15 (RP)

DESIGN	RP	DART AEROSPACE LTD	
DRAWN	RP	HAWKESBURY, ONTARIO, CANADA	
CHECKED	CP	DRAWING NO. D4522	REV. PA3
MFG. APPR.		SHEET 10 OF 24	
APPROVED		TITLE DOOR LATCH ASSY (412)	SCALE NTS
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

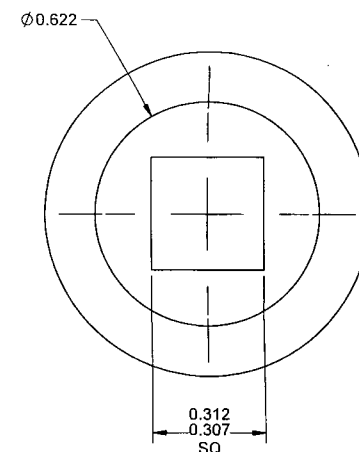
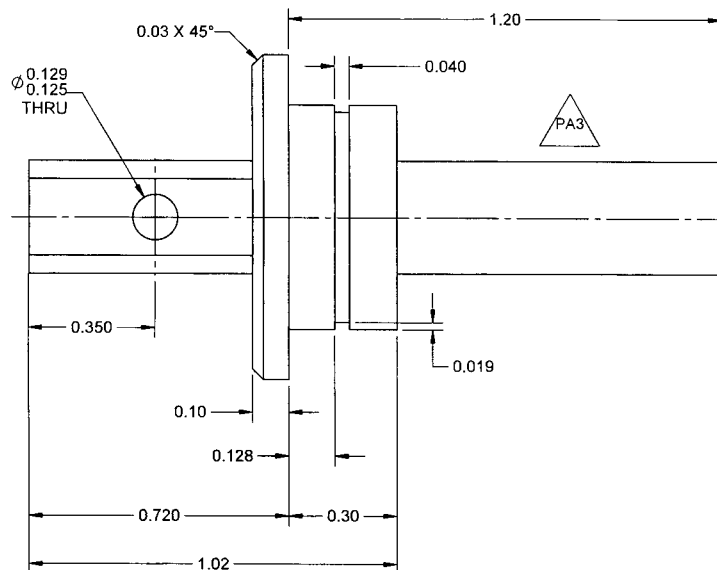
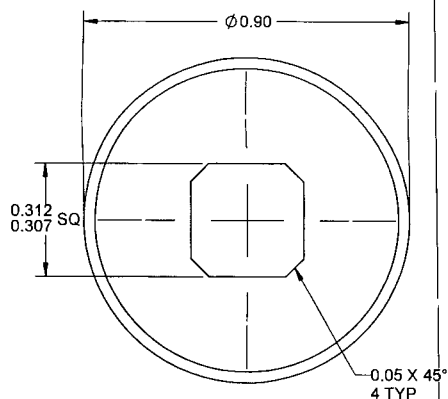
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

00383



D4522-13 HANDLE SHAFT ADAPTER

NOTES:

- 1) MATERIAL: AISI 303 SS ROUND BAR PER ASTM A582
REF DART SPEC M303R1.00 OR
AISI 304/316 SS ROUND BAR PER ASTM A276
REF DART SPEC M304R1.000
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: INDENTIFY PER QSI044 6.1
- 7) WEIGHT: 0.08 lbs

PRELIMINARY A3
12.02.15 (RP)

DESIGN	RP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RP		
CHECKED	CP	DRAWING NO. D4522	REV. PA3
MFG. APPR.			SHEET 11 OF 24
APPROVED		TITLE	SCALE
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

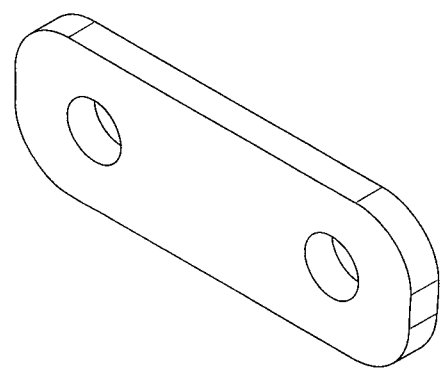
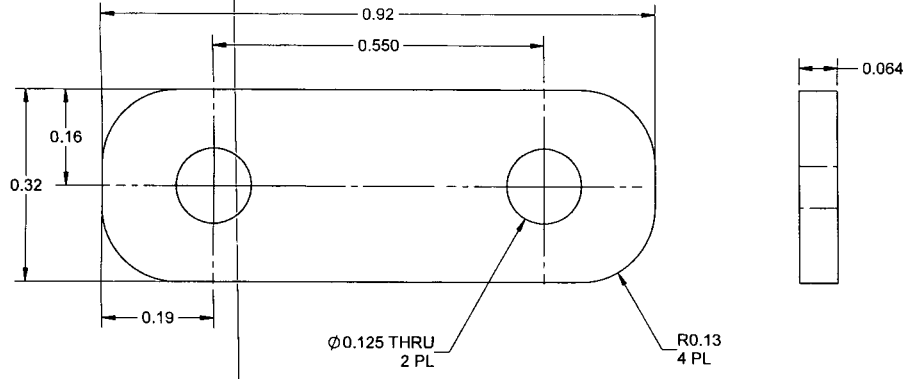
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

80383



D4522-17 LINKAGE

PRELIMINARY A3
12.02.15 (RP)

NOTES:

- 1) MATERIAL: AISI 304/316 SS SHEET, ANNEALED, 2B FINISH
REF DART SPEC M304S16GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI044 6.1
- 7) WEIGHT: 0.01 lbs

DESIGN	RP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RP		
CHECKED	CP	DRAWING NO. D4522	REV. PA3
MFG. APPR.		SHEET 12 OF 24	
APPROVED		TITLE	SCALE
DE APPR.		DOOR LATCH ASSY (412)	NTS
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

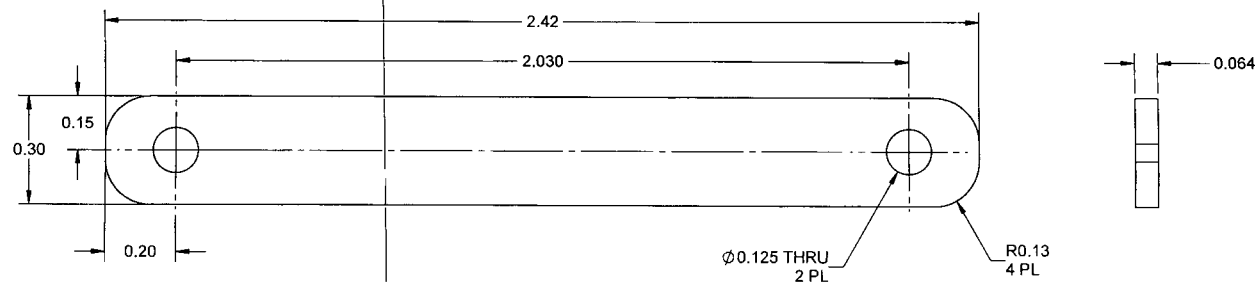
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

0383



D4522-19 LINKAGE

PRELIMINARY A3
12.02.15 (RP)

NOTES:

- 1) MATERIAL: AISI 304/316 SS SHEET, ANNEALED, 2B FINISH
REF DART SPEC M304S16GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI044 6.1
- 7) WEIGHT: 0.01 lbs

DESIGN	RP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RP		
CHECKED	CP	DRAWING NO. D4522	REV. PA3 SHEET 13 OF 24
MFG. APPR.		TITLE DOOR LATCH ASSY (412)	SCALE NTS
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DATE	12.02.15		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

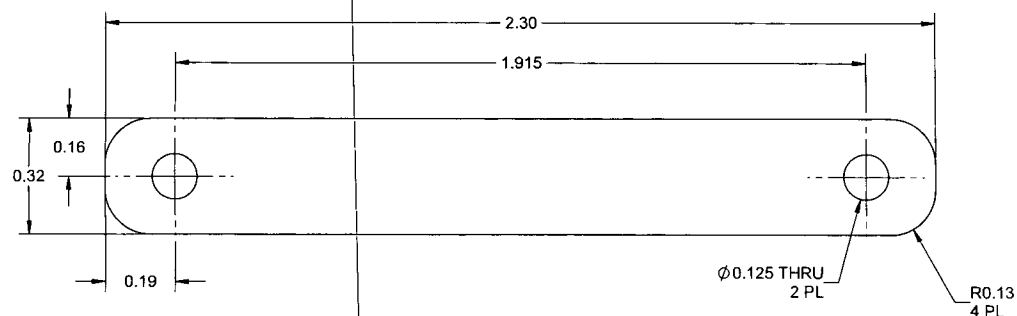
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

80383

**D4522-21 LINKAGE****PRELIMINARY A3**
12.02.15 (RP)**NOTES:**

- 1) MATERIAL: AISI 304/316 SS SHEET, ANNEALED, 2B FINISH
REF DART SPEC M304S12GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI044 6.1
- 7) WEIGHT: 0.02 lbs

DESIGN	RP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RP		
CHECKED	CP	DRAWING NO. D4522	REV. PA3
MFG. APPR.			SHEET 14 OF 24
APPROVED		TITLE DOOR LATCH ASSY (412)	SCALE NTS
DE APPR.		COPYRIGHT © 2012 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	
DATE	12.02.15		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

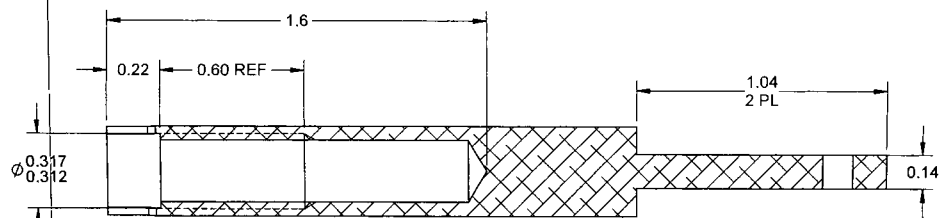
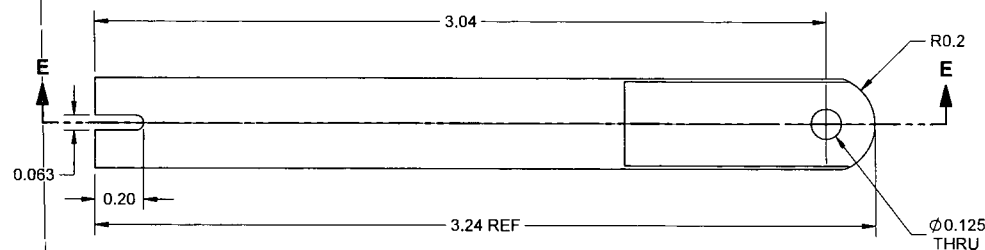
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

80383

5/16-18 UNC-2B
0.60 DP $\phi 0.375$
 $\phi 0.370$ **SECTION E-E****D4522-25 LATCH SHAFT****NOTES:**

- 1) MATERIAL: AISI 303 SS ROUND BAR PER ASTM A582
REF DART SPEC M303B0.375 OR
AISI 304/316 SS ROUND BAR PER ASTM A276
REF DART SPEC M304R0.375
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: N/A

DESIGN	RP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RP		
CHECKED	CP	DRAWING NO. D4522	REV. PA3
MFG. APPR.			SHEET 15 OF 24
APPROVED		TITLE	SCALE
DE APPR.		DOOR LATCH ASSY (412)	NTS
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

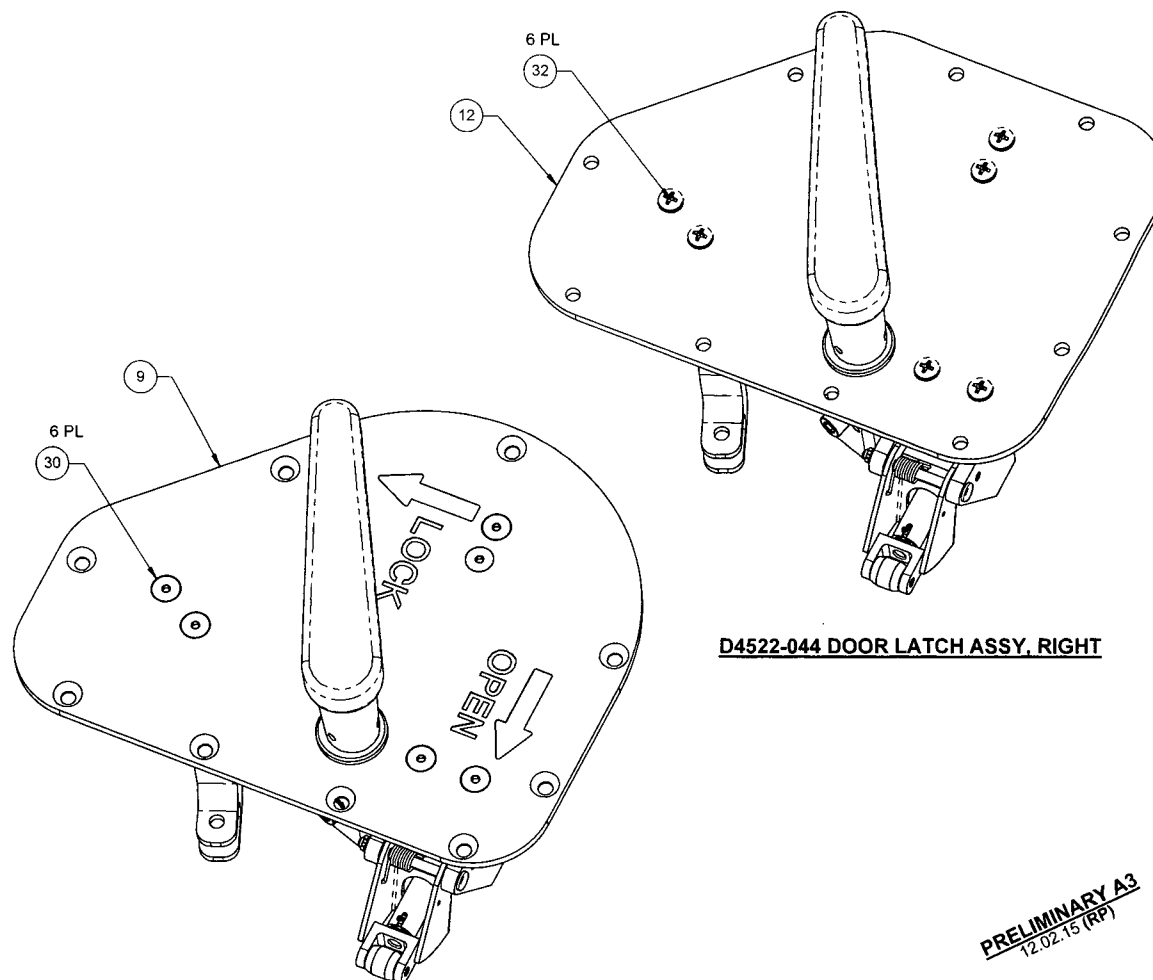
NOTE: Date & initial all entries

20383

ITEM	QTY -042	QTY -044	P/N	DESCRIPTION
	X		D4522-042	DOOR LATCH ASS'Y, RIGHT, OEM
		X	D4522-044	DOOR LATCH ASS'Y, RIGHT
1	1		D4522-045	BASE, HORIZONTAL SWING ARM
2	1		D4522-047	BASE, VERTICAL SWING ARM
3	1		D4522-049	BASE, LATCH SHAFT
4	1	1	D4522-10	VERTICAL SWING ARM
5	1	1	D4522-12	HANDLE SHAFT ARM
6	1	1	D4522-13	HANDLE SHAFT ADAPTER
7	2	2	D4522-17	LINKAGE
8	2	2	D4522-19	LINKAGE
9	1		D4522-2	BASE PLATE, OEM
10	2	2	D4522-21	LINKAGE
11	1	1	D4522-25	LATCH SHAFT
12		1	D4522-31	BASE PLATE
13	1	1	D4529-041	HORIZONTAL SWING ARM
14	1	1	D4530-041	LATCH ROLLER
15	1	1	D4531-1	LATCH SHAFT BRACKET
16	1	1	D4574	INTERIOR L-HANDLE, MODIFIED
17	1	1	LE045005S	EXTENSION SPRING (LEE SPRING)
18	1	1	MS-20995-C20	LOCK WIRE
19	1	1	MS16562-193	SPRING PIN
20	1	1	MS16562-223	SRPING PIN
21	1	1	MS16562-227	SPRING PIN
22	1	1	MS16624-4062	EXTERNAL RETAINING RING
23	1	1	MS20392-1P41	DRILLED PIN
24	1	1	MS20392-1R27P	DRILLED PIN
25	1	1	MS20392-1R37P	DRILLED PIN
26	4	4	MS20392-1R9P	DRILLED PIN
27	3	3	MS20392-2R41P	DRILLED PIN
28	7	7	MS24665-151	COTTER PIN
29	2	2	MS24665-155	COTTER PIN
30	6		MS24671-14	SCREW, FL-HD, HEX, #8
31	1	1	MS24674-13	DRILLED CAP SCREW, #10
32		6	MS51957-43	SCREW, PN-HD, #8
33	5	5	NAS1149-C-N432-R	FLAT WASHER
34	1	1	NAS42DD628FC	SPACER
35	1	1	T032-180-156L	TORSION SPRING

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY PER DART QSI 044
- 7) WEIGHT: 2.0 lbs
- 8) INSTALL ALL COTTER PINS AND LOCK WIRE IN ACCORDANCE WITH MS33540
- 9) OEM VERSION DEPICTED IN DRAWING
- 10) SHEETS 22-24 ARE FOR REFERENCE ONLY AND ARE ONLY **RECOMMENDED** ASSEMBLY STEPS

**D4522-042 DOOR LATCH ASSY, RIGHT, OEM**

DESIGN	RP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RP		
CHECKED	CP	DRAWING NO. D4522	REV. PA3
MFG. APPR.			SHEET 16 OF 24
APPROVED		TITLE	SCALE
DE APPR.		DOOR LATCH ASSY (412)	NTS
DATE	12.02.15	COPYRIGHT © 2012 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

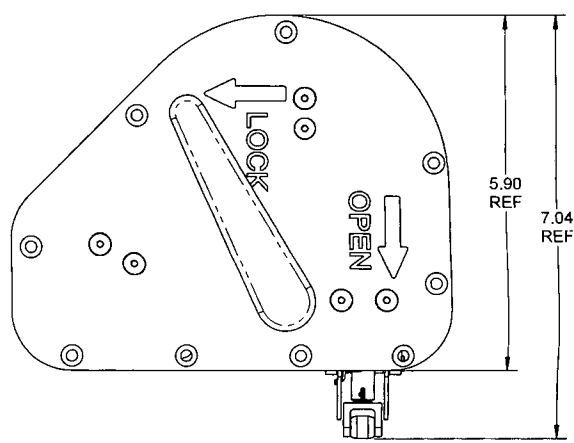
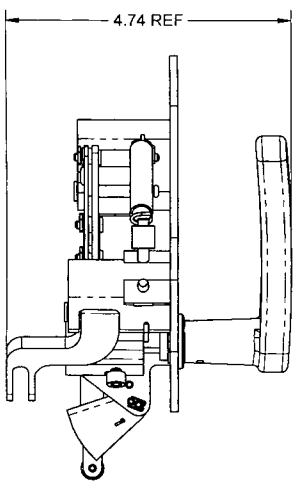
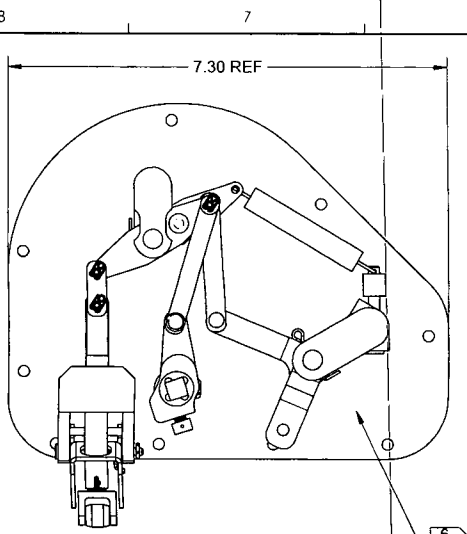
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

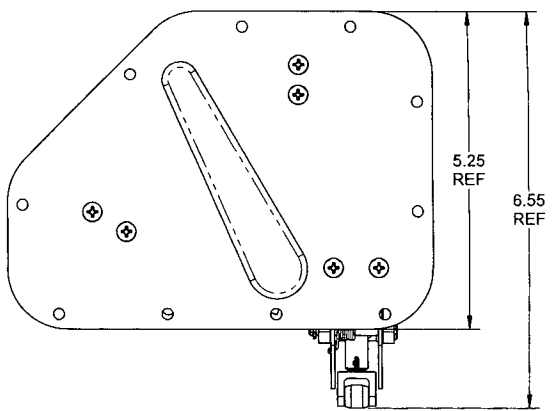
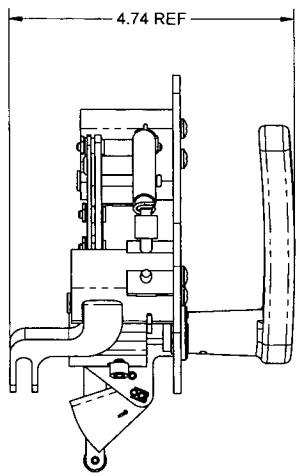
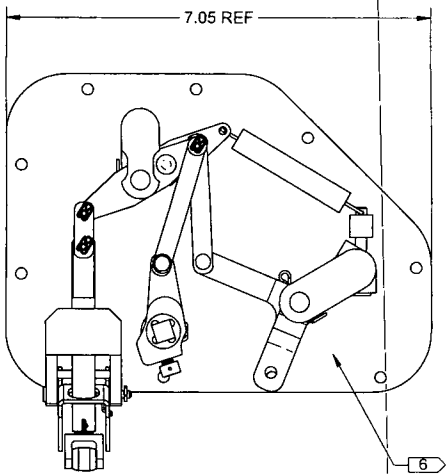
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

803 83



D4522-042 DOOR LATCH ASSY, RIGHT, OEM



D4522-044 DOOR LATCH ASSY, RIGHT

PRELIMINARY A3
12.02.15 (RP)

DESIGN	RP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RP		
CHECKED	CP	DRAWING NO. D4522	REV. PA3 SHEET 17 OF 24
MFG. APPR.		TITLE DOOR LATCH ASSY (412)	SCALE NTS
APPROVED		<small>COPYRIGHT © 2012 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	
DE APPR.			
DATE	12.02.15		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

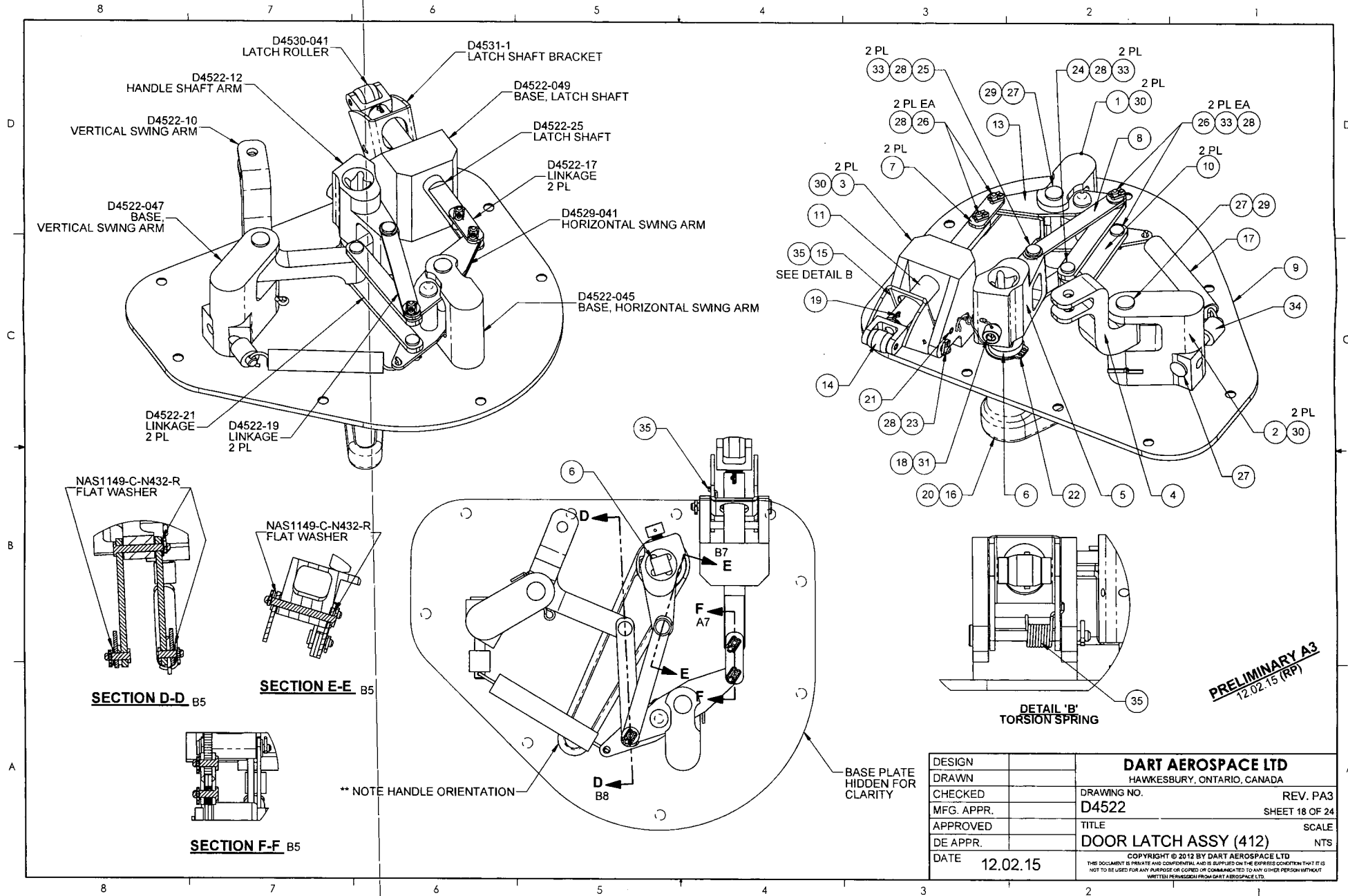
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

80383



PRELIMINARY A3
12.02.15 (RP)

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO. D4522	REV. PA3
MFG. APPR.			SHEET 18 OF 24
APPROVED		TITLE	SCALE
DE APPR.		DOOR LATCH ASSY (412)	NTS
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Dart Aerospace Ltd

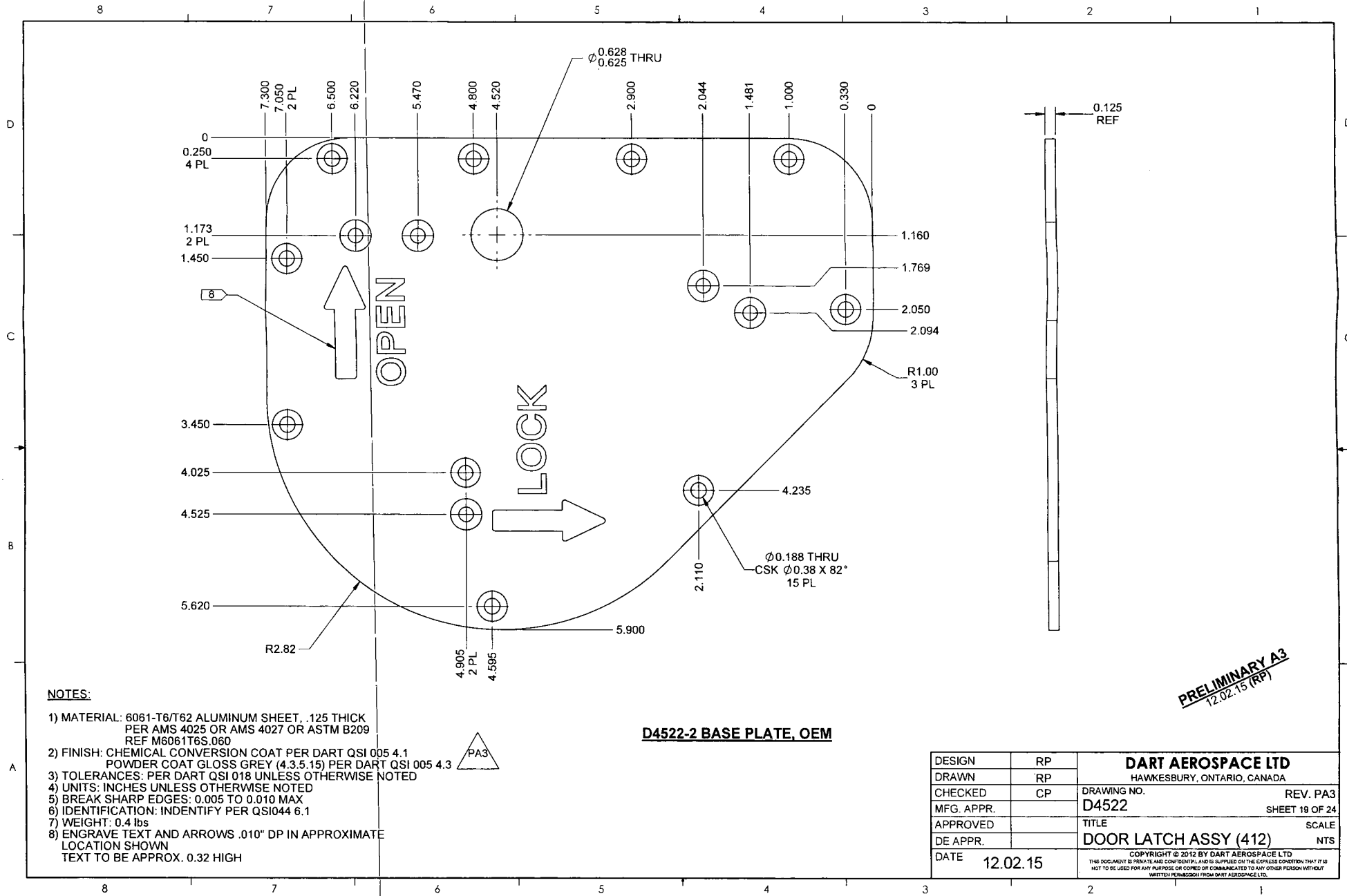
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

00383



NOTES:

- 1) MATERIAL: 6061-T6/T62 ALUMINUM SHEET, .125 THICK
PER AMS 4025 OR ASTM B209
REF M6061T6S.060
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GLOSS GREY (4.3.5.15) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI044 6.1
- 7) WEIGHT: 0.4 lbs
- 8) ENGRAVE TEXT AND ARROWS .010" DP IN APPROXIMATE
LOCATION SHOWN
TEXT TO BE APPROX. 0.32 HIGH



D4522-2 BASE PLATE, OEM

PRELIMINARY A3
12.02.15 (RP)

DESIGN	RP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RP		
CHECKED	CP	DRAWING NO.	REV. PA3
MFG. APPR.		D4522	SHEET 18 OF 24
APPROVED		TITLE	SCALE
DE APPR.		DOOR LATCH ASSY (412)	NTS
DATE	12.02.15	<small>COPYRIGHT © 2012 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

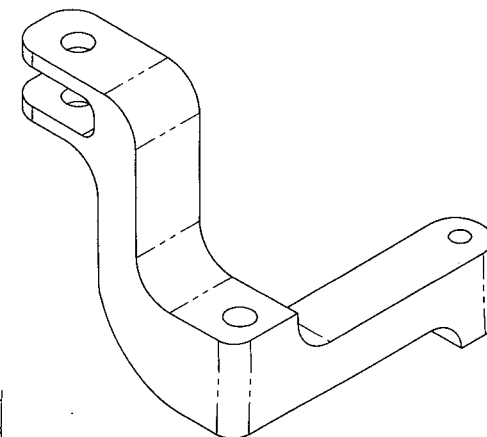
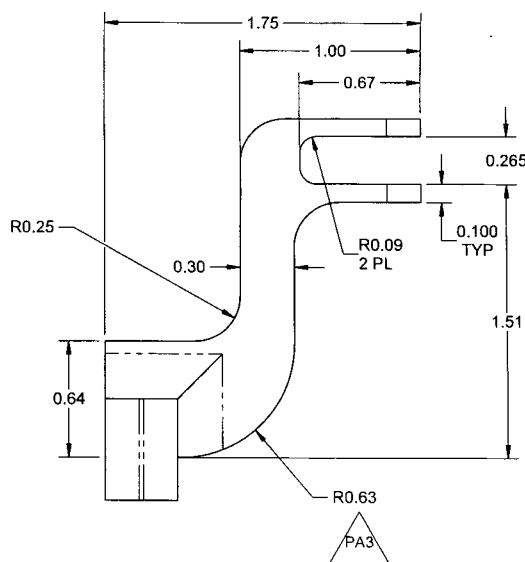
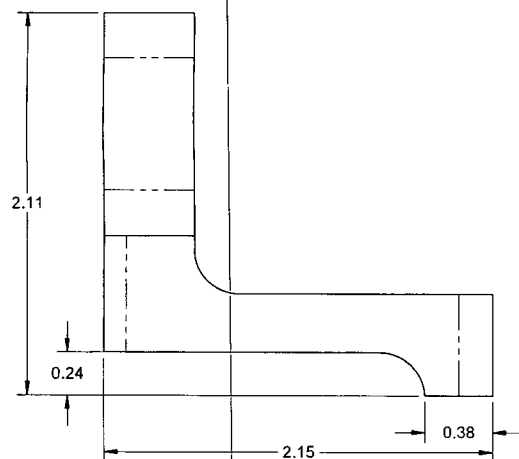
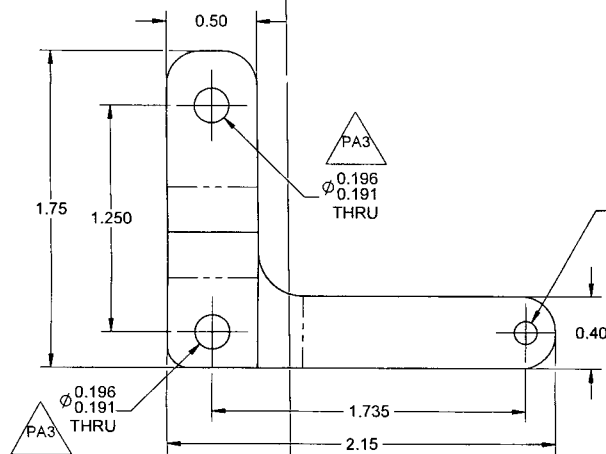
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

80383



NOTES:

- 1) MATERIAL: AISI 303 SS BAR PER ASTM A582
REF DART SPEC M303B OR
AISI 304/316 SS BAR OR PLATE
PER ASTM A276 OR ASTM A240
REF DART SPEC M304B
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI044 6.1
- 7) WEIGHT: 0.19 lbs

D4522-10 VERTICAL SWING ARM

PRELIMINARY A3
12.02.15 (RP)

DESIGN	RP	DART AEROSPACE LTD	
DRAWN	RP	HAWKESBURY, ONTARIO, CANADA	
CHECKED	CP	DRAWING NO.	REV. PA3
MFG. APPR.		D4522	SHEET 20 OF 24
APPROVED		TITLE	SCALE
DE APPR.		DOOR LATCH ASSY (412)	NTS
DATE	12.02.15	COPYRIGHT © 2012 BY DART AEROSPACE LTD. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE REPRODUCED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

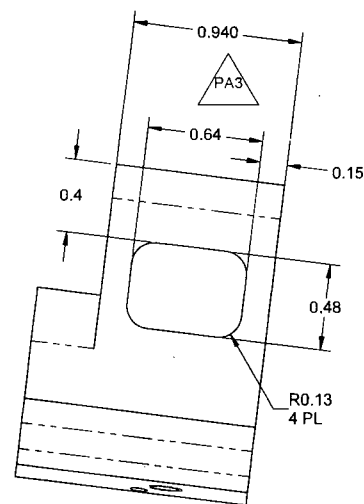
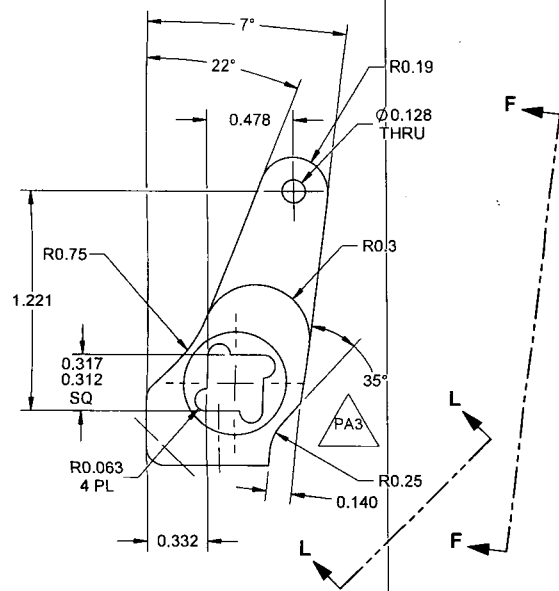
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

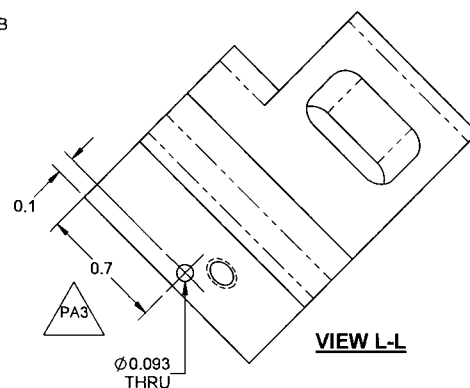
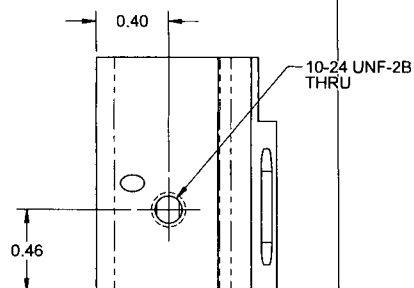
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

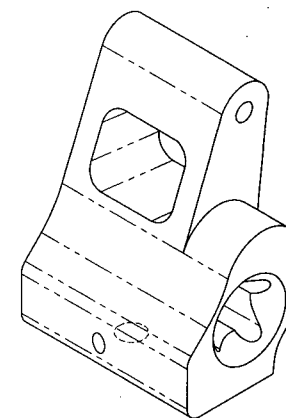
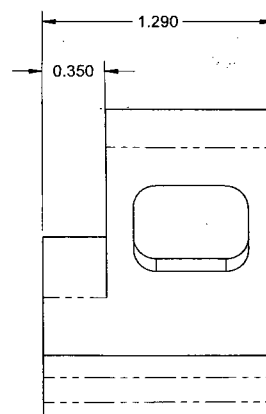
20383



VIEW F-F



VIEW L-L



PRELIMINARY A3
12.02.15 (RP)

NOTES:

- 1) MATERIAL: AISI 303 SS BAR PER ASTM A582
REF DART SPEC M303B OR
AISI 304/316 SS BAR OR PLATE
PER ASTM A276 OR ASTM A240
REF DART SPEC M304B
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI044 6.1
- 7) WEIGHT: 0.14 lbs

D4522-12 HANDLE SHAFT ARM

DESIGN	RP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RP		
CHECKED	CP	DRAWING NO. D4522	REV. PA3 SHEET 21 OF 24
MFG. APPR.		TITLE DOOR LATCH ASSY (412)	SCALE NTS
APPROVED		<small>COPYRIGHT © 2012 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	
DE APPR.			
DATE	12.02.15		

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

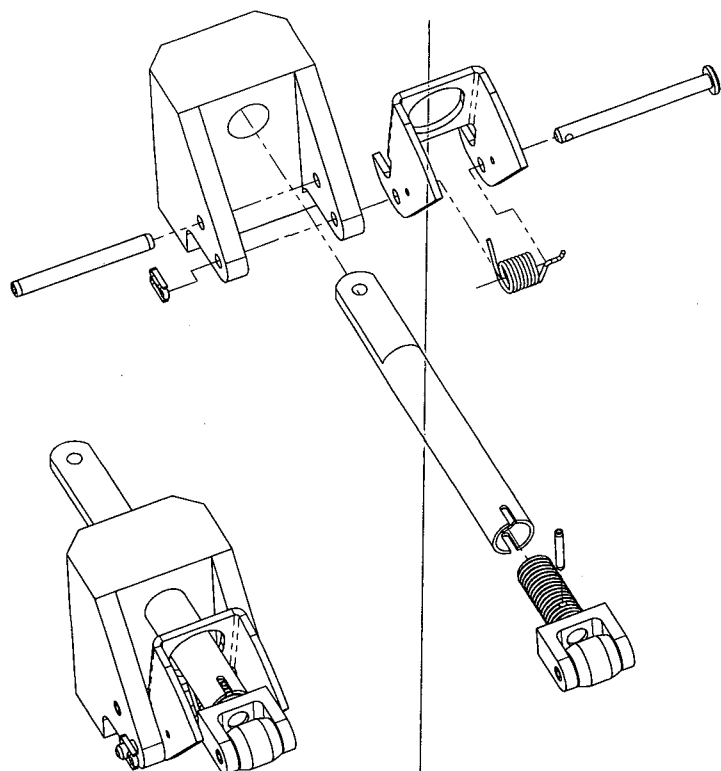
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

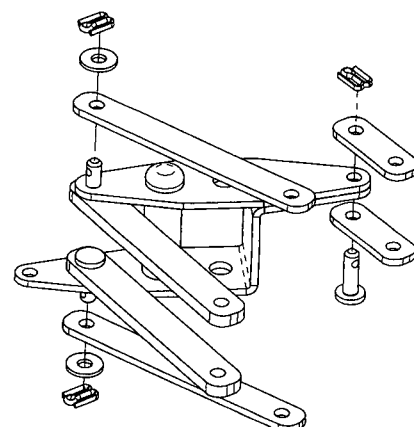
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

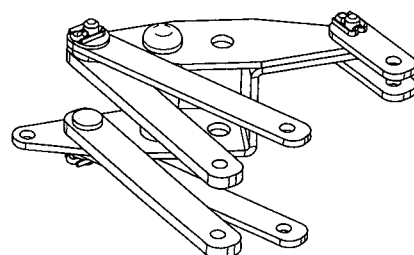
80383



RECOMMENDED ASSEMBLY STEP #1A
(LATCH SUB-ASSEMBLY)



RECOMMENDED ASSEMBLY STEP #1B
(LINKAGE SUB-ASSEMBLY)



DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO. D4522	REV. PA3
MFG. APPR.			SHEET 22 OF 24
APPROVED		TITLE	SCALE
DE APPR.		DOOR LATCH ASSY (412)	NTS
DATE	12.02.15	<small>COPYRIGHT © 2012 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSES OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

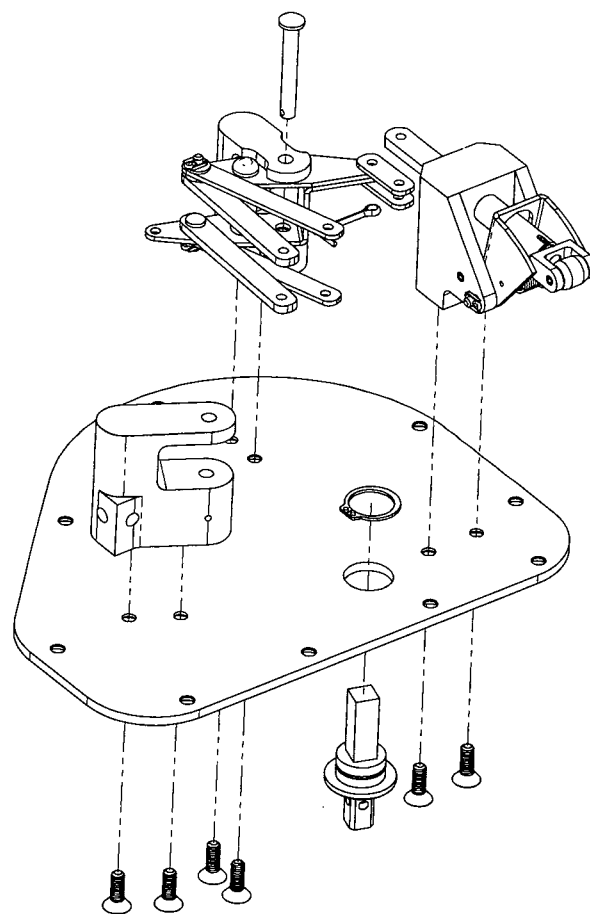
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

803.83



RECOMMENDED ASSEMBLY STEP #2
(MAIN COMPONENTS TO BASE PLATE)

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. PA3
MFG. APPR.		D4522	SHEET 23 OF 24
APPROVED		TITLE	SCALE
DE APPR.		DOOR LATCH ASSY (412)	NTS
DATE	12.02.15	<small>COPYRIGHT © 2012 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

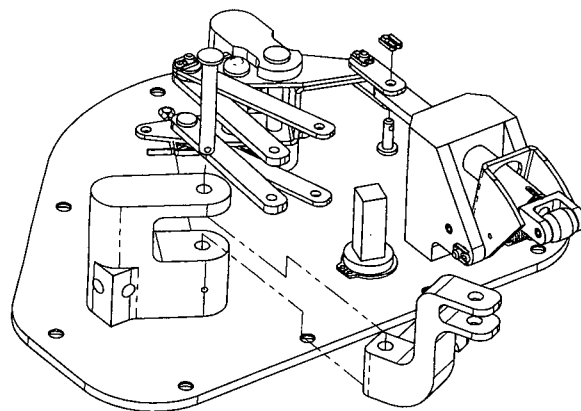
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

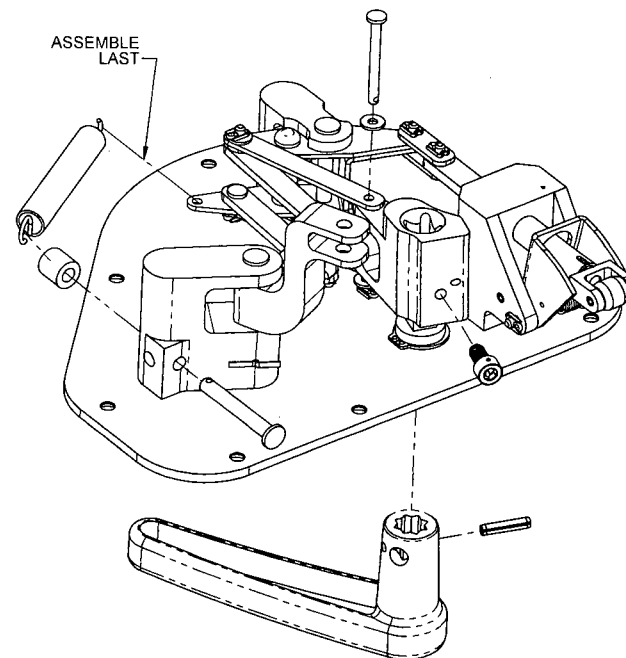
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

0323



RECOMMENDED ASSEMBLY STEP #3
(VERTICAL SWING ARM, TENSION SPRING, LATCH LINKAGE)



RECOMMENDED ASSEMBLY STEP #4
(HORIZ SWING ARM & HANDLE)

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. PA3
MFG. APPR.		D4522	SHEET 24 OF 24
APPROVED		TITLE	SCALE
DE APPR.		DOOR LATCH ASSY (412)	NTS
DATE	12.02.15	<small>COPYRIGHT © 2012 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DAN'S PRECISION TOOLS INC.

2560 Devine Road, Vars, ON K0A3H0
Tel: (613) 835-3097 Fax: (613) 835-3760
support@dans-precision-tools.com

RE: CERTIFICATE OF COMPLIANCE

To: DART AEROSPACE LTD.
1270 Aberdeen Street
Hawkesbury ON K6A-1K7
Tel: (613) 632-5200
Fax: (613) 632-5246

- We Certify that the part listed below meets the intent of the Purchase Order, and all applicable drawings and specifications.

Date : 09-Apr-12

Purchase Order : PO16235

Packing Slip : 11282

Part Number : D4522-3revPA3

Quantity : 2

Per. _____


For Dan's Precision Tools Inc.

DAN'S PRECISION TOOLS INC.

Customer: DART AEROSPACE LTD.

P.O.: PO16235

W/O: _____

Part #: D4522-3 rev PA3

Base, Horizontal Swing Arm

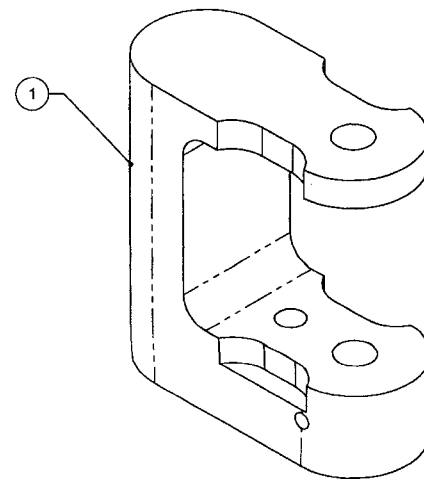
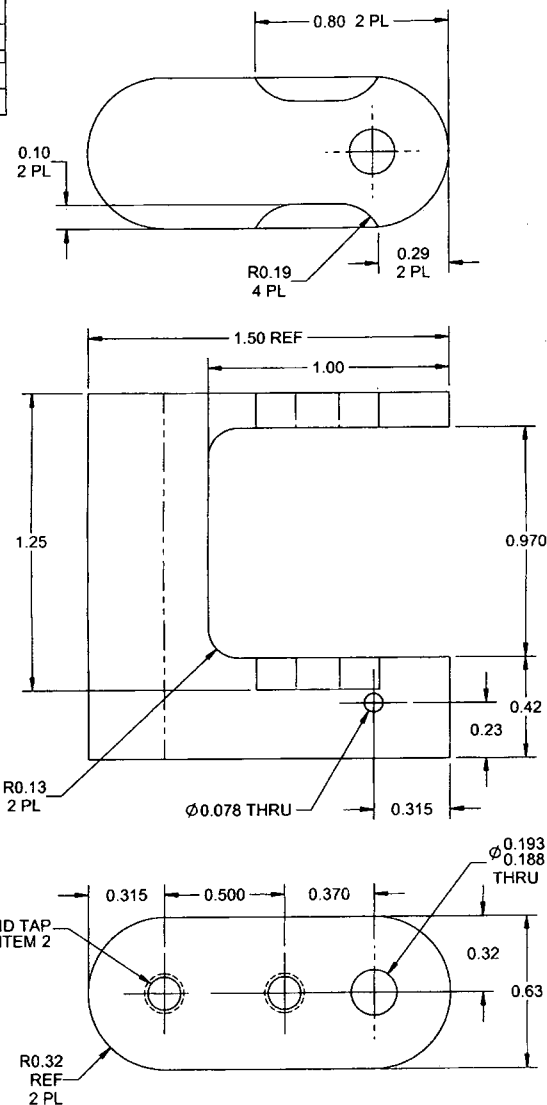
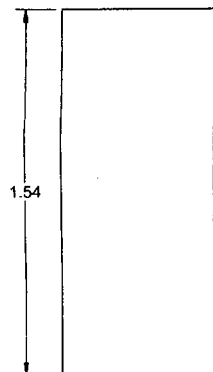
Qty: 2

1

of

1

ITEM	QTY -045	P/N	DESCRIPTION
	X	D4522-045	BASE, HORIZONTAL SWING ARM
1	1	D4522-3	BASE, HORIZONTAL SWING ARM
2	2	MS21209-C0820	THREADED INSERT, 8-32 UNC X 0.33 LG



- NOTES:
- 1) MATERIAL: 6061-T6/T651/T6510/T6511/T62 ALUMINUM BAR
PER QQ-A-225/8 OR AMS-QQ-A-225/8 OR
AMS 4117/4128/4115/4116 OR QQ-A-200/8 OR
AMS 4160 OR ASTM B211 OR ASTM B221
REF DART SPEC M6061T6B
 - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: PER DART QSI 044 6.6 OR 6.7
 - 7) WEIGHT: 0.07 lbs

D4522-045 BASE, HORIZONTAL SWING ARM

80383

RELEASED
2012-06-13

DESIGN	RP	DART AEROSPACE LTD	
DRAWN	RP	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D4522	SHEET 9 OF 23
APPROVED		TITLE	SCALE
DE APPR.		DOOR LATCH ASSY (412)	NTS
DATE	12.04.17	<small>COPYRIGHT © 2012 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD</small>	